DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-026246
Date Inspected: 31-Aug-2011

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1530
Location: Jobsite

CWI Name:	As noted			**CWI Present:**	☑ Yes	☐ No	
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☑ Yes	☐ No	☐ N/A
Electrode to specification:	☑ Yes	☐ No	☐ N/A	**Weld Procedures Followed:**	☑ Yes	☐ No	☐ N/A
Qualified Welders:	☑ Yes	☐ No	☐ N/A	**Verified Joint Fit-up:**	☑ Yes	☐ No	☐ N/A
Approved Drawings:	☑ Yes	☐ No	☐ N/A	**Approved WPS:**	☑ Yes	☐ No	☐ N/A
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A

Bridge No: 34-0006
Component: SAS OBG

Summary of Items Observed:

Quality Assurance Inspector (QA) Douglas Frey was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

1. 10E PP87.2 Pipe Welding (Exterior)
2. 10E PP89.5 Pipe Welding (Exterior)
3. 11E PP95 Drip Rails (Exterior)
4. 10E PP89.2 Pipe Welding (Exterior)
5. 11E 12E Bottom Plate D (Interior)

1. 10E PP87.2 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing SMAW in the 3G vertical position on 2.5 and 4 inch schedule 80 pipe located at 10E PP87.2 weld #25/2.5/87/NE and weld #25/4/87/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes all of which in an uphill progression.
The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

2. 10E PP89.5 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing SMAW in the 3G vertical position on 2.5 and 4 inch schedule 80 pipe located at 10E PP89.5 weld #27/2.5/89/NE and weld #27/4/89/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes all of which in an uphill progression.
The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

3. 11E PP95 (Exterior) Drip Rails

The QA Inspector made periodic observations of ABF welder Mike Jimenez ID# 4671 performing SMAW in the 4G overhead position on Drip Rails located outside of the OBG at 11E PP95. The QA Inspector observed the QC Inspector Tony Sherwood monitor the welding and ensure the welding parameters were in compliance pertaining to ABF-WPS-D15-1200A Rev. 1. The work is in progress and the QA Inspector noted that the work appeared to be in general conformance with the contract documents.

4. 10E PP89.2 Pipe Welding (Exterior)

The QA inspector observed F.W. Spencer welder Curtis Jump ID# 7326 performing SMAW in the 1G flat and 3G vertical positions on 2.5 and 4 inch schedule 80 pipe located at 10E PP89.2 weld #26/2.5/89/NE and weld #26/4/89/NE. The QA inspector verified the fit up of the joints and found it to be satisfactory. The QA inspector observed the QC inspector identified as Steve Jensen monitoring the welding to ensure the welding parameters were in compliance pertaining to WPS-1-12-1 Revision 2 (1.12). The welder was observed implementing 6010 electrodes in the root pass with the balance using 7018 electrodes all of which in an uphill progression.
The QA inspector made subsequent observations throughout the shift to monitor quality and noted that the work appeared to be in general conformance with the contract documents.

5. 11E 12E Bottom Plate D (Interior)

The QA Inspector noted the dimensions of the indications at D1 y+800 x+10 as 30mm’s in length, and 9mm’s depth, y+805 x+5 as 20mm’s in length and 17mm’s in depth, y+915 x+5 as 25mm’s in length and 13mm’s depth, y+1930 x+2 as 20mm’s in length and 14mm’s depth, y+2040 x+15 as 20mm’s in length and 12mm’s depth. The QA Inspector observed the QC Inspector identified as Pat Swain perform Ultrasonic inspection and recorded the dimensions. The QA inspector verified that the proper procedure was utilized as well as correct technique and noted that the work appeared to be in general conformance with the contract documents.

Summary of Conversations:

At the beginning the shift the QA inspector met with QC inspector William Sherwood and discussed the welders assignments and locations for the shift to include pending issues, ongoing work and required testing.

WELDING INSPECTION REPORT

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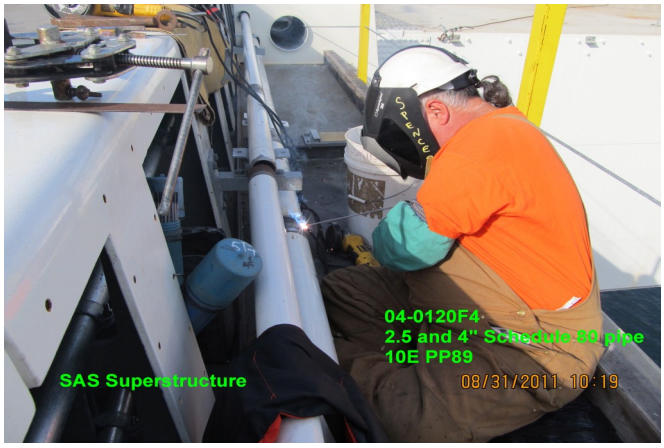

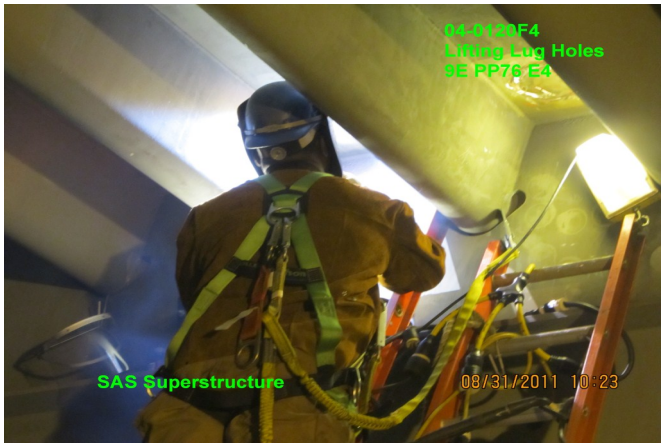

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy 510-385-5910, who represents the Office of Structural Materials for your project.

Inspected By:	Frey,Doug	Quality Assurance Inspector
Reviewed By:	Levell,Bill	QA Reviewer